

Work Order ID 82910

April-10-12 2:47:22 PM

82910

Page 1

Item ID: D2671 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206 Narrow
 Start Date: 10/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2671	Rev B1								

120
120 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut Blank as per File D2671_BLANK
 UHMW 1" Blk
 (4) 12-4-20

130
130 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1
 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671
 3-Deburr
 PD/B. 12/04/27 4 4

140
140 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control
 PD/B. 12/04/27 4 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82910

April-10-12 2:47:22 PM

82910

Page 2

Item ID: D2671 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206 Narrow
 Start Date: 10/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12-05-3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:47:26 PM

Page 1

Work Order ID: 82910

82910

Parent Item: D2671

D2671

Parent Item Name: Bearpaw, 206 Narrow

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	324.5100	2.7	10.8			

MUHMWB10

UHMW 1" Black

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	3.009994737	
120401	0.00999474	
120972	3	
MAT019	1.5	
118814	1.5	
ST052	320	
121277	20	
121278	300	

121278

JM
12-4-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82910
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671	Rev: B1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45°	✓		PHD-01	VERN
B	5.500	+/-0.030	5.501	✓		"	"
C	0.200	+/-0.030	0.195	✓		PHD-09	
D	R0.250	+/-0.030	0.250	✓		Rat gauge	
E	0.625	+/-0.030	0.627	✓		PHD-01	VERN
F	0.250	+/-0.010	0.257	✓		HB 120	MIC
G	0.950	+0.030/-0.010	0.956	✓		PHD-01	VERN
H	0.25 x 45°	+/-0.030	0.250x45°	✓		PHD-11	M TAPE
I	0.375	+/-0.010	0.375	✓		PHD-01	VERN
J	12.750	+/-0.030	12.750	✓		PHD-11	M TAPE
K	Ø0.260	+0.005/-0.000	Ø 0.260	✓		Pin gauge	
L	Ø0.93	+/-0.030	0.930	✓		PHD-01	VERN
M	0.30	+0.030/-0.000	0.308	✓		PHD-09	
N	4.250	+/-0.030	4.255	✓		PHD-01	VERN
O	0.375	+/-0.030	0.380	✓		"	"
P	2.000	+/-0.030	2.000	✓		"	"
Q	4.250	+/-0.010	4.255	✓		"	"
R	9.000	+/-0.010	9.004	✓		H. gauge	
S	15.750	+/-0.030	15.750	✓		PHD-11	M TAPE

Measured by:	PD / S.A.
Date:	12/04/27

Audited by:	2P
Date:	12.5.2

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

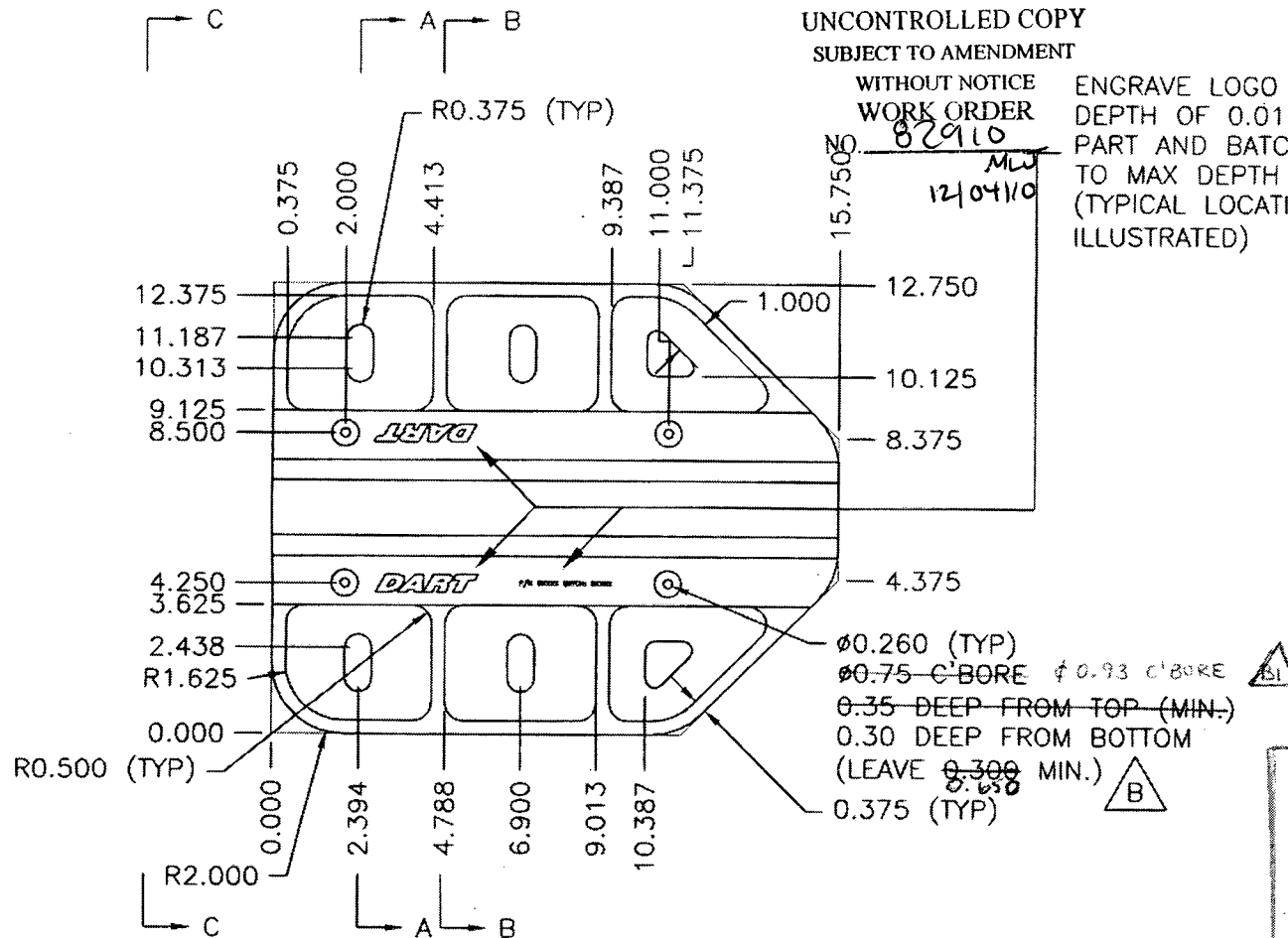
B1	02.12.17	$\phi 0.93$ was $\phi 0.75$ 持
----	----------	-------------------------------

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
- PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DART



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

Copyright 1997 by DART AEROSPACE LTD

48.06.17 KE

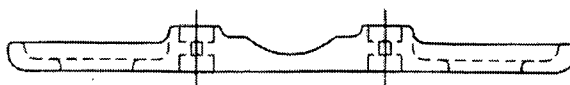
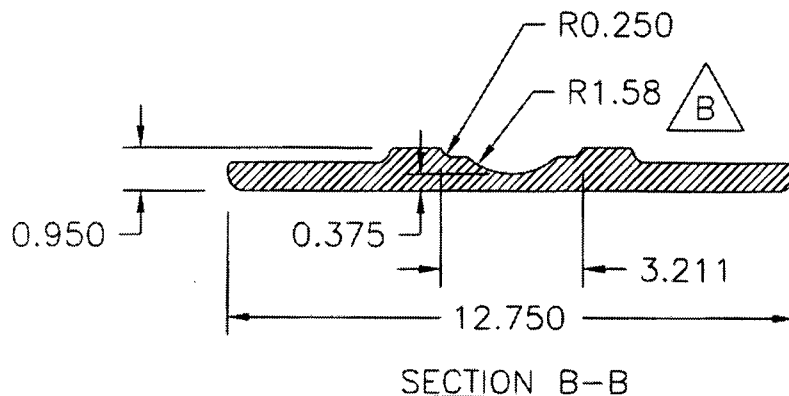
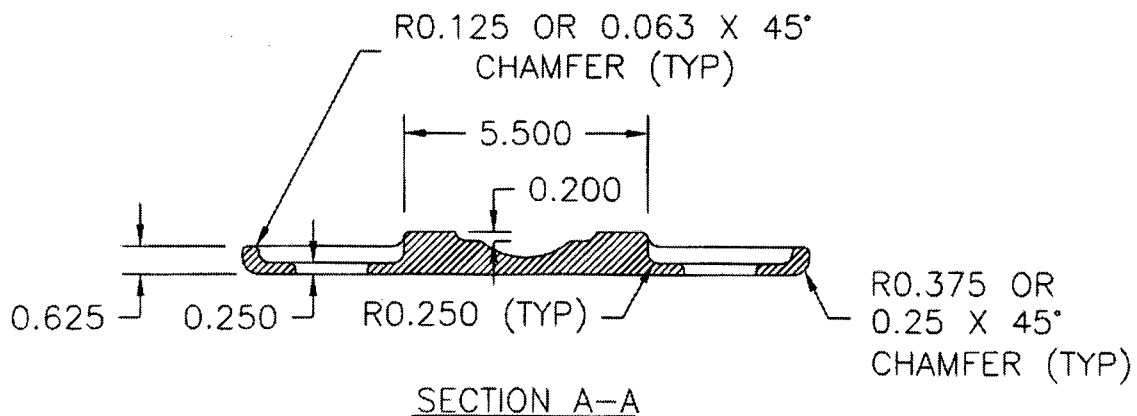
EFFECTIVE DEOS

CHECKED <i>KE</i>		DRAWING NO.	REV. B
APPROVED <i>AS</i>		D2671	SHEET 1 OF 2
DATE		TITLE	
98.05.19		BEARPAW	
A		97.04.08	
B		98.05.19	
CHANGE C'BORE, R1.58 WAS R1.50		SCALE 1:5	



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



SECTION C-C

82910